

Work Order ID 56781

March 10, 2010 7:22:05 AM

Page 1

Item ID: D3467-048

Accept

Setup Start

Revision ID:

Stop

Item Name: Cover Plate Assembly RH

Start Date: 3/10/10 Start Qty: 1.00

Cust Item ID:

Required Date: 3/15/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3467

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D3467; 12-Spot Weld as per Dwg D3467 and Dart QSI
004 113-Identify as D3467-048

EMK

10/03/10

110

0.00



QC11- Inspect spot weld per QSI004

QC

Memo

0.00

Quality Control

ETS 10/03/10

①

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Sabirio

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3467-048

Accept



Setup Start



Revision ID:

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Item Name: Cover Plate Assembly RH

Start Date: 3/10/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/15/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: C-A

0.00



Packaging

Memo

0.00

Packaging

Handwritten signature and date: 3/10/10

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Handwritten signature and date: 10/03/11
mf 10-3-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 56781

Parent Item: D3467-048

Parent Item Name: Cover Plate Assembly RH


Start Date: 3/10/10

Required Date: 3/15/10

Comments: IPP Rev: A New Issue 06-04-24 EC
IPP Rev: B As per Rev B 06-05-24 JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3467-2		Manufactured	No				Each	2.0000	1.0000			
												
Cover Plate RH												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST153

2

55953

2

Each

4.0000

1.0000

D3467-7

Manufactured

No



Seal Strip

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST059

4

36104

4

ES 10/03/10

1

ES 10/03/10

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

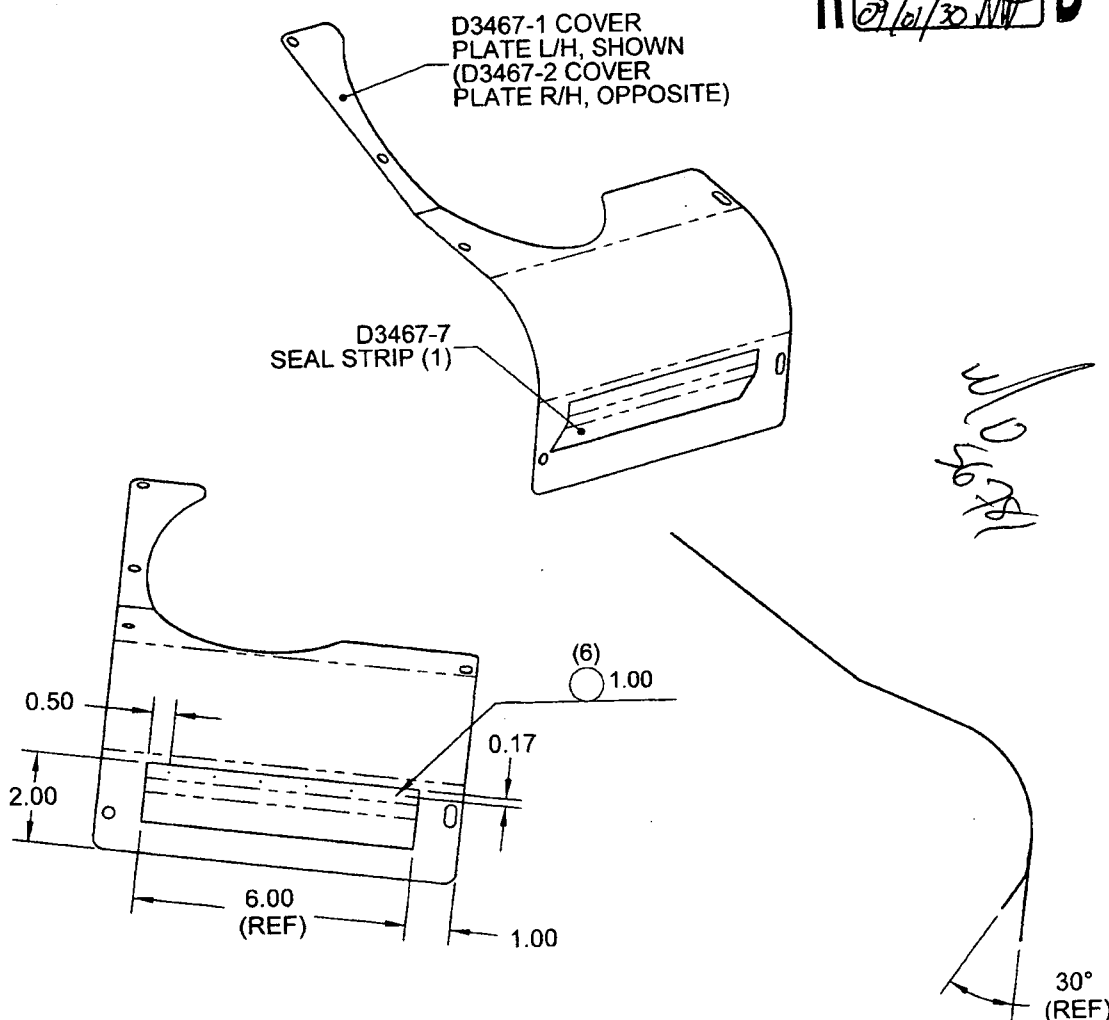
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3467	REV. C SHEET 4 OF 15
DATE 08.12.19		TITLE SHROUD ASSEMBLY SCALE 1:4	

RELEASED
[Handwritten: 09/01/30 MW]



D3467-047 COVER PLATE ASS'Y L/H, SHOWN
D3467-048 COVER PLATE ASS'Y R/H, OPPOSITE

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -047	QTY -048	P/N	DESCRIPTION
X		D3467-047	COVER PLATE ASSEMBLY, L/H
	X	D3467-048	COVER PLATE ASSEMBLY, R/H
1		D3467-1	COVER PLATE, L/H
	1	D3467-2	COVER PLATE, R/H
1	1	D3467-7	SEAL STRIP

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NOTE: Date & initial all entries

SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 77

EMPLOYEE: Marc Gregory

PART NUMBER: D3467-048

JOB NUMBER: B 56781

MATERIAL TYPE: _____

MATERIAL THICKNESS: _____

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PENETRATION:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 10/03/10

QUALIFIER: SB